

Work Order ID 56355 - 1

Thursday, February 18, 2010 4:21:19 PM

SPUR



Item ID: D2535

Accept



Setup Start



Revision ID:

Item Name: Spring

Stop



Start Date: 2/19/2010 Start Qty: 40.00

Required Date: 2/22/2010 Req'd Qty: 40.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *MF* Date: *10-2-15*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2535

Rev A

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: *11387* Possible Supplier: Victoria Spring, 0.070 SS Torsion Spring

BT 10-2-15
(40)

110

0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

Rec'd 22 57

120

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

Check dims to dwg

Sublot 122

count to
(X52)
QSP019

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56355

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Customer:

Reference:

Run Start



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Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

Packaging

Handwritten: C10/22 (57)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Handwritten: 10/02/23

Handwritten: ME 10-2-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Page 1

Work Order ID: 56355



Parent Item: D2535



Parent Item Name: Spring



Start Date: 2/19/2010

Required Date: 2/22/2010

Comments: IPP AL99.04.19 New Issue (From hand written IPP) DM

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2535P		Purchased	No			100	Each	0.0000	40.0000			
												
Spring												

MF 10-2-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

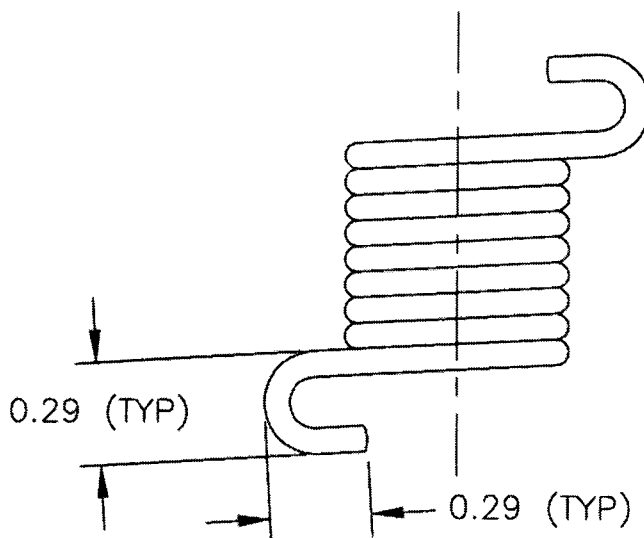
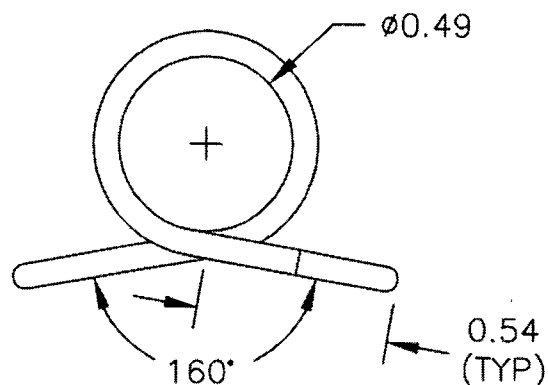
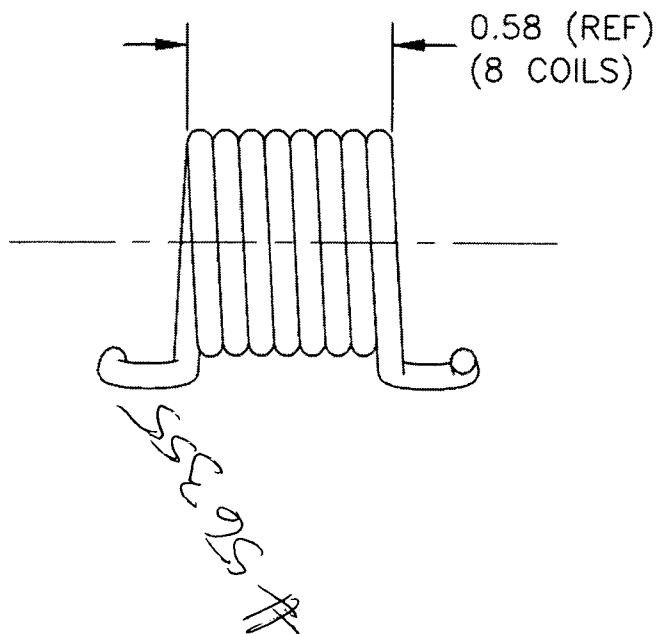
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RE	APPROVED [Signature]	DRAWING NO. D2535	REV. A SHEET 1 OF 1
DATE 99.04.08		TITLE SPRING SPEC CONTROL	SCALE 2:1
A	99.04.08	NEW ISSUE	

RELEASED
99.05.11 RE



SPECIFICATION CONTROL DRAWING

TENSION SPRING WITH 8 COILS (NO GAP BETWEEN COILS)

MATERIAL: AISI STAINLESS STEEL $\phi 0.070$

POSSIBLE SUPPLIERS: VICTORIA SPRINGS, P/N .070SS TENSION SPRING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

CERTIFICATE OF CONFORMANCE

REPORT FOR : Dart Aerospace	DATE: 2/19/2010
PART/DRAWING #: D2535P	PO # 11387
SPRING DESCRIPTION: Torsion Spring	QUANTITY: 57

S. 10/02/22

CHARACTERISTIC	SPECIFIED	MEASURED	NOTES
Material type	SS T302	yes	
Material diameter	0.07	0.072	
Coil I.D.	0.490	0.490 - 0.505	
Number of Coils	8 ref	8 ref	
Free Length			
Helix	RHW	yes	
End type	As per Dwg	yes	

COMMENTS

Mill Certificate attached: NO

Material Heat Number:

Inspected by: *Chris Burrowes*



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO11387

Purchase Order Date 2/18/10

PO Print Date 2/19/10

Page Number 1 of 1

Order From :

VC-VIC002

VICTORY SPRING LTD.
#2 6104 - 82 AVE.
EDMONTON, AB T6B 0E7
CA

Contact Name
Vendor Phone 866 230 5312
Vendor Fax 866 230 5338
Vendor Account Nbr

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB

REVISED
2/19/10
RECEIVED
FEB 19 2010

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2535P	Spring	2/22/10 Yes	100.00 Each	FedEx Overnight	\$4.5600	\$456.00
Special Inst: As per DGW D2535 REV: A B# 56355							
PO Total:							\$456.00

100.00
10/1/10

Pls ship what you have today
the rest can be B/O

Thank you

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 2

Change Date: 2/19/10